

Work Order ID 68458

Wednesday, April 13, 2011 3:28:43 PM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

11-04-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

D4042

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *115528*

0.00

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

11-04-19

110



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

0.00

Memo

0.00

1 *8* *BE 11/04/20*
11-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 11-4-25

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo 11/6964.

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 11:30

OVEN TEMPERATURE: 400°

FINISH TIME: 12:00

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 BR 11-4-25.

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Signature: [Handwritten Signature] 5/4/26

W/O:		WORK ORDER CHANGES					
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Revision ID:					Stop	
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Start Date:	4/13/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/20/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish	Assemble as per dwg	0.00							
Hand Finishing	Memo Pick Kit	0.00							<i>ES 4/04/26</i>
160 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							<i>8/11/04/26</i>
170 Packaging	Identify as per dwg & Stock Location: <i>6A</i>	0.00							
Packaging	Memo <i>w/o 68457</i>	0.00							<i>ES 4/04/26</i>

W/O:		WORK ORDER CHANGES					
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Required Date: 4/20/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/4/26 
ms
11-04-26

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Picklist Print

Wednesday, April 13, 2011 3:28:50 PM

Page 1

Work Order ID: 68458

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/13/2011





Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	26.0000	2	2			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA005			26						
				66500			4						
				66806			22						
D3913-1  Rib		Manufactured	No			100	Each	3.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			3						
				68184			3						
D3913-15  Wide Handle Plate		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			2						
				67751			2						
				WA005			3						
				68176			3						
D3913-3  Rib		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA006			1						
				67475			1						

Ppl 11.04.19

2

Ppl 11.04.19

1

Ppl 11.04.19

1

Ppl 11.04.19

1

W/O:		WORK ORDER CHANGES					
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Work Order ID: 68458

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-7

 Rib

Manufactured No

100 Each

8.0000

2 2



Ppl 11.04.19

Location

Loc Qty

Loc Code

WA006

8

65278

1

66435

1

67982

6

②

D3913-9

 Hinge Rib

Manufactured No

100 Each

4.0000

1



Ppl 11.04.19

Location

Loc Qty

Loc Code

WA006

4

66630

1

68186

3

①

D3916-041

 Rib Assembly

Manufactured No

100 Each

3.0000

2



Ppl 11.04.19

Location

Loc Qty

Loc Code

WA

3

67276

3

①

B67983 → ②

D3916-5

 Light Rib

Manufactured No

100 Each

5.0000

3



Ppl 11.04.19

Location

Loc Qty

Loc Code

WA006

5

67979

5

③

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Work Order ID: 68458



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-1

 Hinge Half, Base

Manufactured No 100 Each 22.0000 3 3



Cpl 11.04.19

Location Loc Qty Loc Code

WA 18
 66418 0
 67473 18
 WA005 4
 66418 4

(2)
(1)

D4017-7

 Rib

Manufactured No 100 Each 3.0000 1



Cpl 11.04.19

Location Loc Qty Loc Code

WA005 3
 67478 3

(1)
 2

D4017-9

 Rib

Manufactured No 100 Each 6.0000 2



Cpl 11.04.19

Location Loc Qty Loc Code

WA006 6
 67978 6

(2)
 2

D4020-11

 End Mesh, Basket

Manufactured No 100 Each 10.0000 2



Cpl 11.04.19

Location Loc Qty Loc Code

WA 10
 61306 1
 67458 9

(2)

W/O:		WORK ORDER CHANGES					
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Wednesday, April 13, 2011 3:28:51 PM

Page 4

Work Order ID: 68458

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-1

 Handle Plate

Manufactured No 100 Each 12.0000 3 3



Cpl 11-04-19

Location Loc Qty Loc Code

WA 12
 67474 12

D4034-041

 Aft Upper Rib Assembly

Manufactured No 100 Each 4.0000 1



3

Cpl 11-04-19

Location Loc Qty Loc Code

WA006 4
 66884 1
 67980 3

D4034-043

 Fwd Upper Rib Assembly

Manufactured No 100 Each 3.0000 1



1

Cpl 11-04-19

Location Loc Qty Loc Code

WA006 3
 67981 3

M304EX0.75-16F

 Expanded Metal Flat SS

Purchased No 100 sf 449.1926 33



1

Cpl 11-04-19

Location Loc Qty Loc Code

WA 449.1926
 115012 150
 117197 299.1926

33

Wednesday, April 13, 2011 3:28:51 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 68458

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No

150

Each

122.0000

6

6



Bolt

Location

Loc Qty

Loc Code

ST351

122

116400

22

117313

100

AN960JD8 NAS1149DN832J Purchased No

150

Each

0.0000

2

2



Washer

LD M117316

(2x)

D2931 Manufactured No

150

Each

690.0000

2

2



Bumper

Location

Loc Qty

Loc Code

ST504

690

46064

690

D4021-5 Manufactured No

150

Each

5.0000

2

2



Blanking Plate

Location

Loc Qty

Loc Code

WA005

5

67008

5

MS20600-AD4W3 Purchased No

150

Each

877.0000

2

2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

456

111636

456

WA018

421

107939

421

EPB 11/04/26

1
5
EPB 11/04/26

2
EPB 11/04/26

2
EPB 11/04/26

68261(2)
EPB 11/04/26

2
EPB 11/04/26

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, April 13, 2011 3:28:51 PM

Page 6

Work Order ID: 68458

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,874.000

6



Nut

Location

Loc Qty

Loc Code

ST300

1874

116391

300

116540

800

116549

774

6
EP 4/04/20

NAS1149F0332P

Purchased

No

150

Each

198.0000

12



WASHER

Location

Loc Qty

Loc Code

ST275

198

17317

198

12
EP 4/04/20
12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

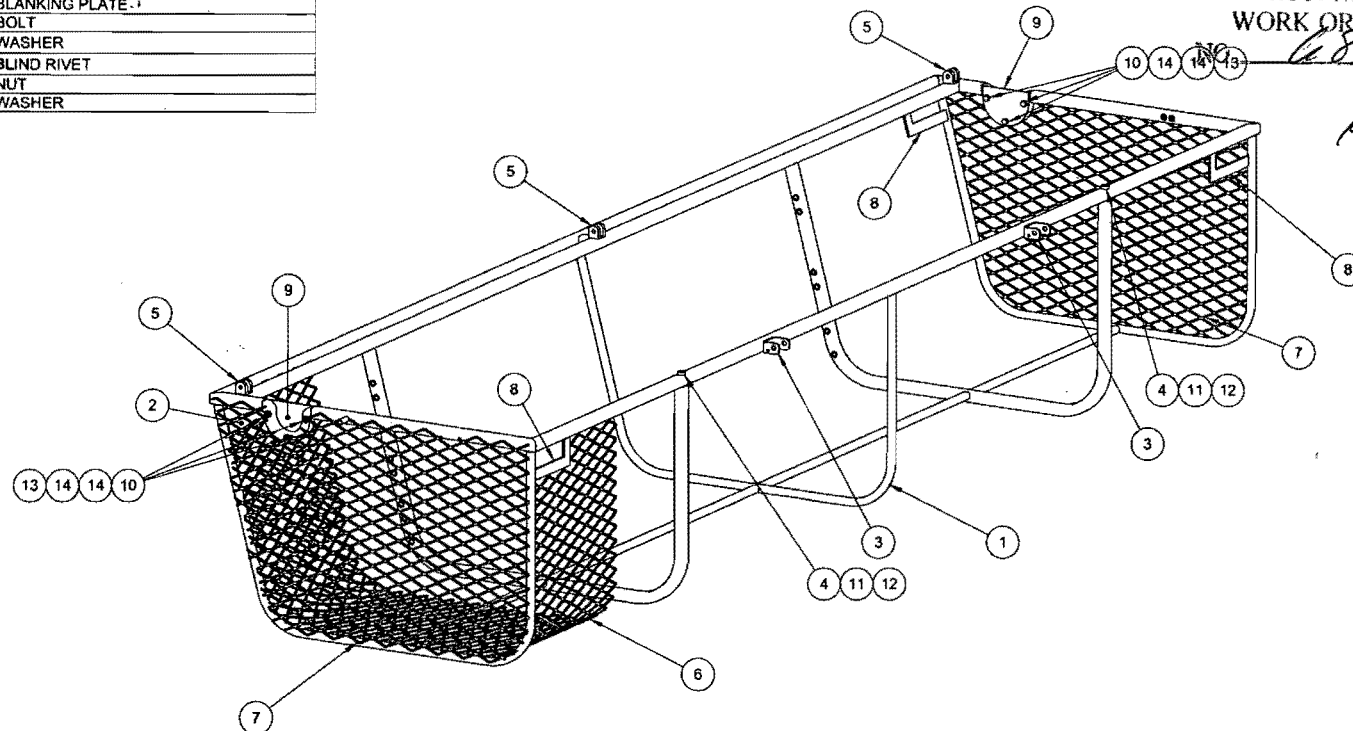
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

28458
211-04-13

RELEASED
2010-03-22

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JFH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A
SHEET 1 OF 6

TITLE **LONG BASKET BASE ASSY (350)** SCALE NTS

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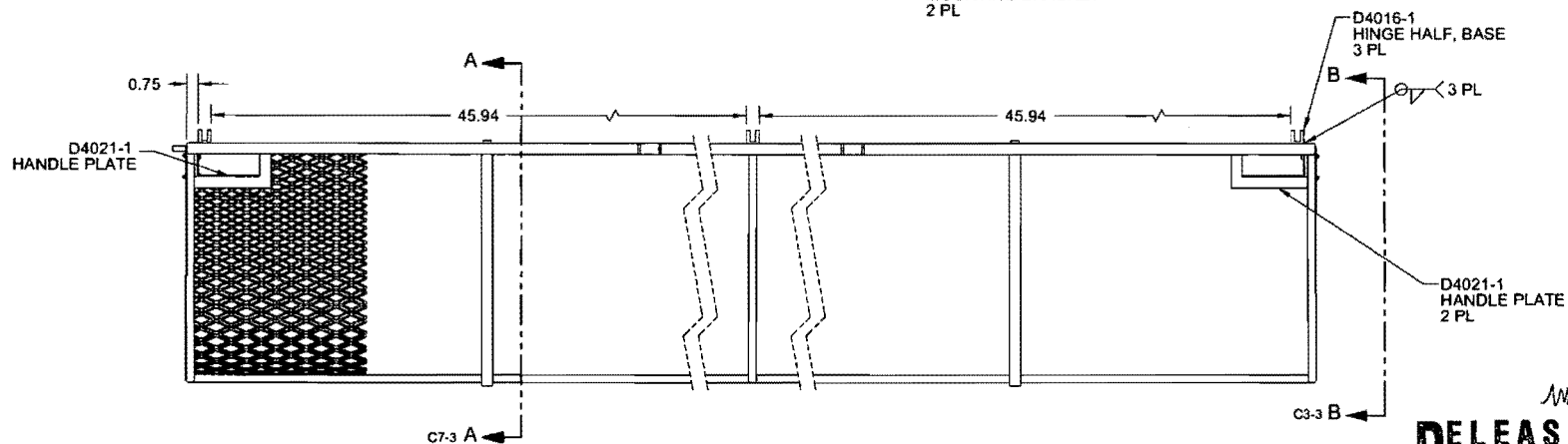
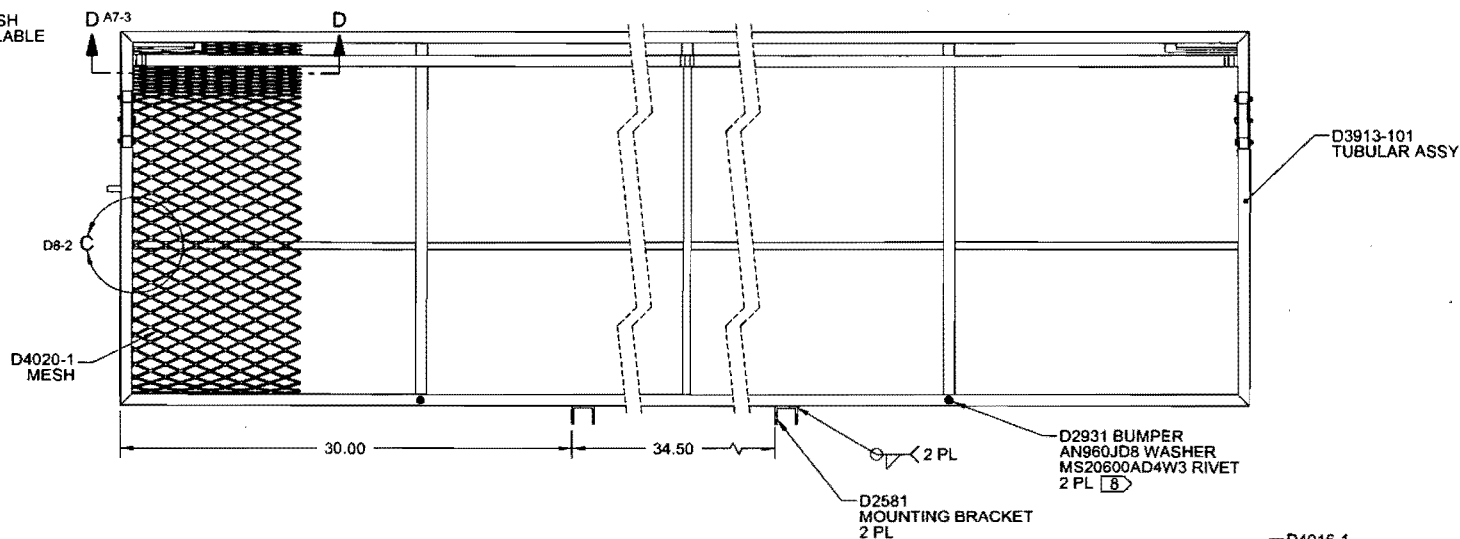
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-07-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

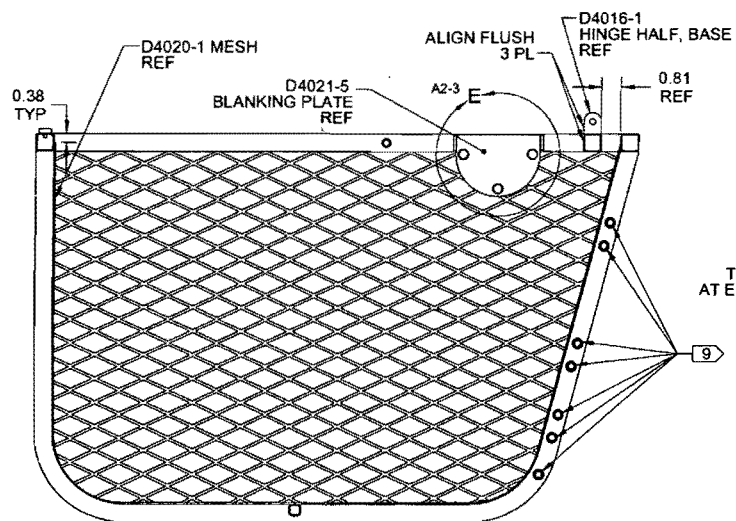
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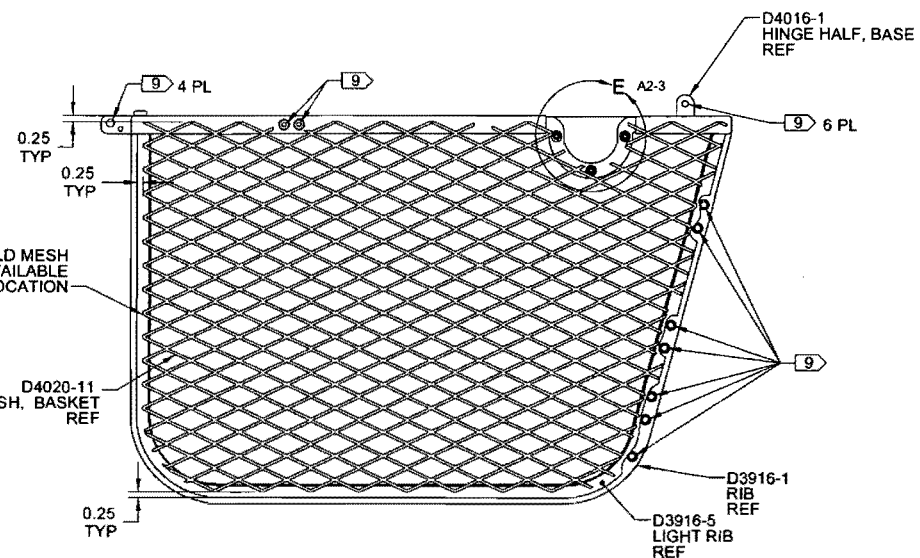
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

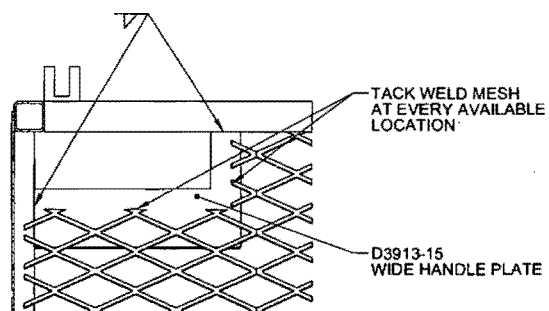
NOTE: Date & initial all entries



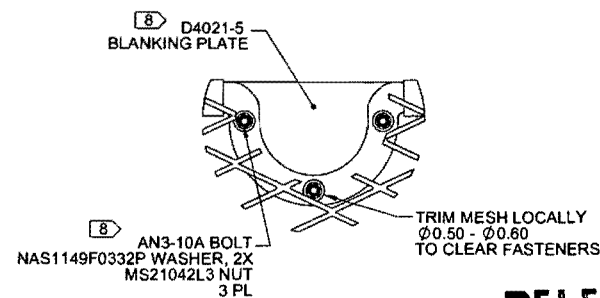
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

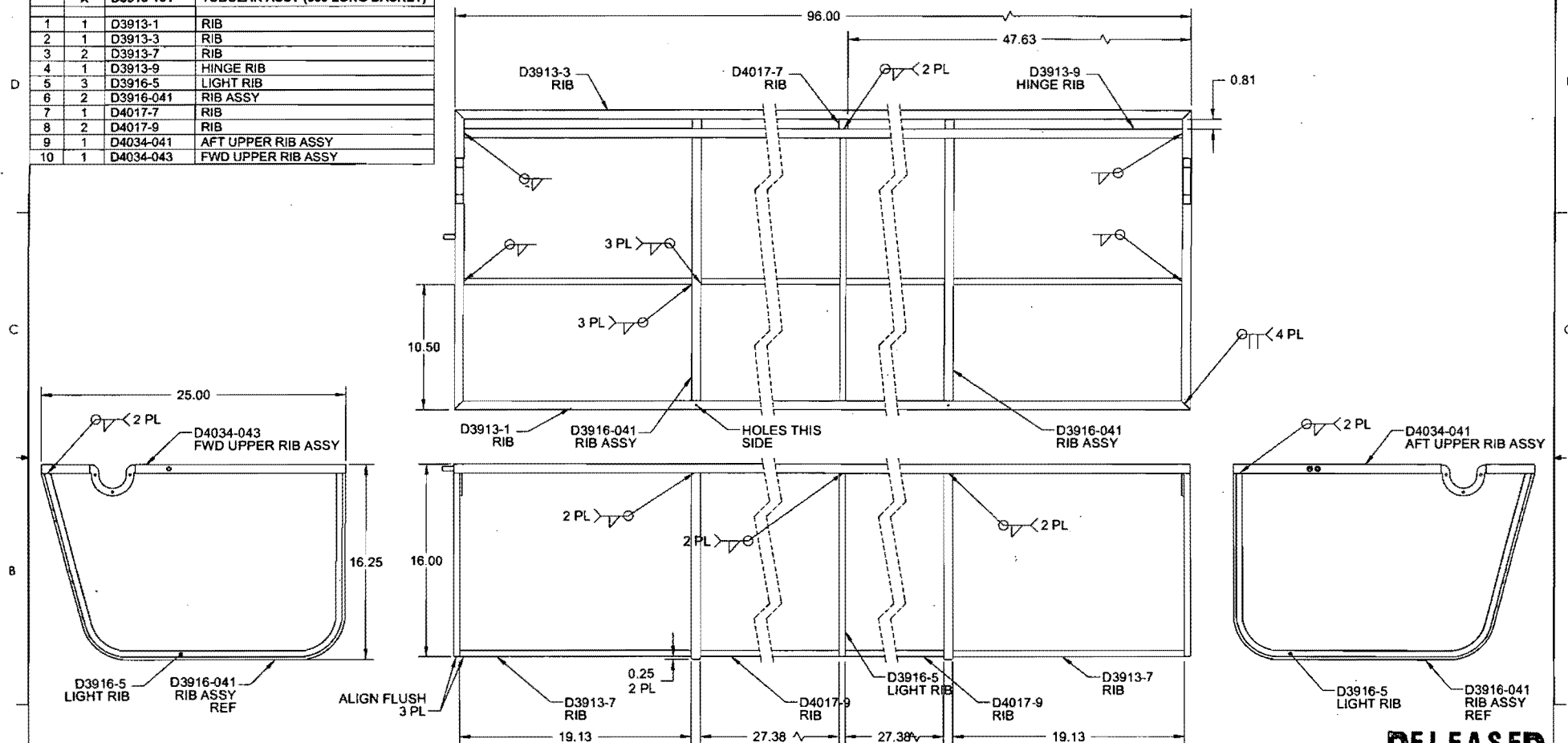
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



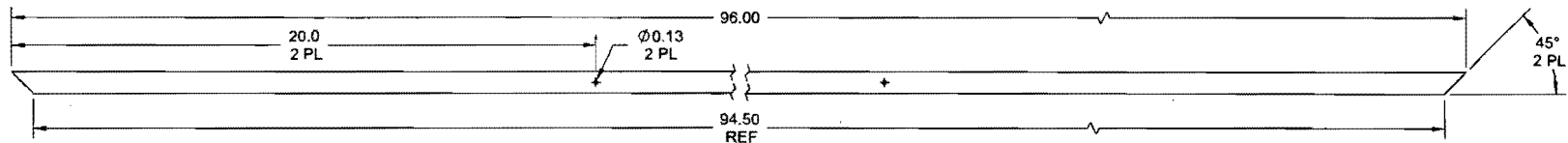
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

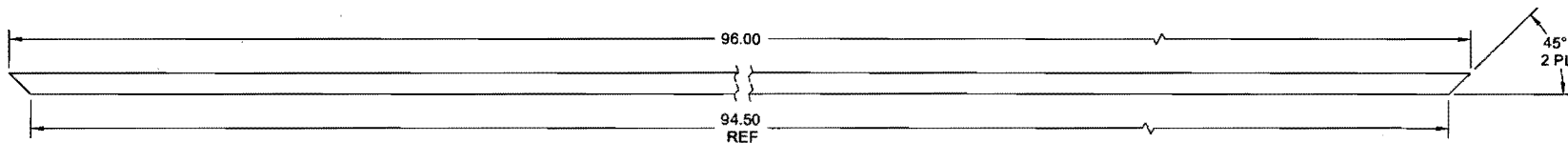
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.		SHEET 4 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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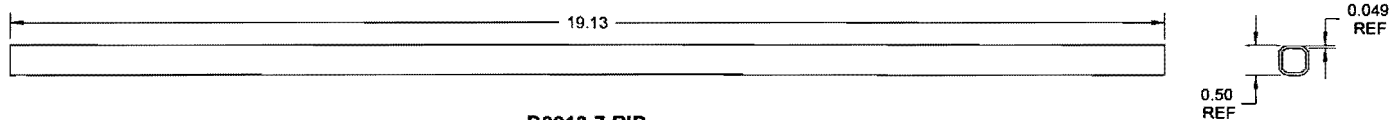
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2010-03-22



D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

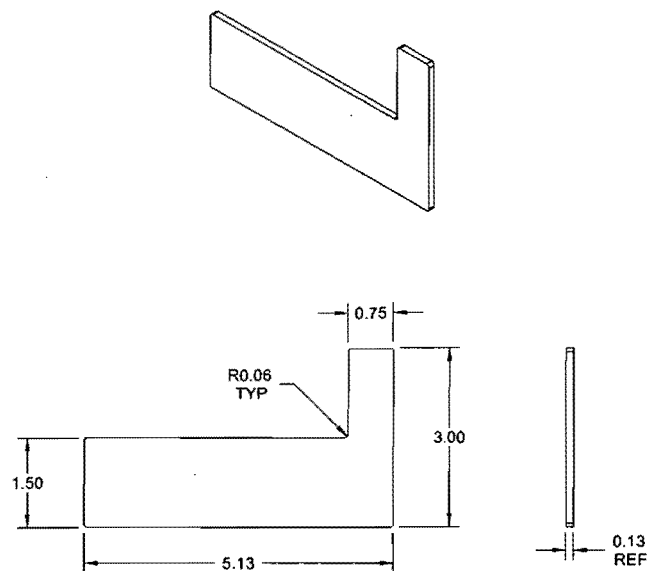
1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2010-03-22
WJP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3913	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 6	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
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